

Work Order ID 82597

82597

Page 1

April-03-12 11:27:18 AM

Item ID: D412-761-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Modified Latch Mechanism, LH

Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/03 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI9580

A

IIN D412-761

Rev D

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D412-761-043 CHG001

0.00

0.00

0.00

0.00

110

110

Packaging

Packaging

Pick Kit

Memo

AS 15 12 30

1002 per EN 12562

3 MLJ 12-11-30

(3)

12/11/28

DAS 20

12/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82597

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Page 2

Item ID: D412-761-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Modified Latch Mechanism, LH
 Start Date: 03/04/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 17/04/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				3			
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-761-043 Location: 2031A F4 PPP Rev: _____	0.00 0.00				3x		12/11/30	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

12/12/30
 MJS 12-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

April-03-12 11:27:22 AM











82597

D412-761-043

Required Date: 17/04/2012

Required Qty: 3.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP REV:B
11.11.29 AS PER DSI9580 DD VEF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-041 *D3589-041* LATCH ASSEMBLY		Manufactured	No			110	Each	0.0000	 **	3 88451 JB	-		
D3589-047 *D3589-047* FWD GUIDE		Manufactured	No			110	Each	0.0000	 **	3 88272 JB	-		
D3589-049 *D3589-049* Aft Guide		Manufactured	No			110	Each	0.0000	 **	3 88485			
MS16997-24 *MS16997-24* SCREW		Purchased	No			110	Each	4.0000	 **	6 121321 JB	✓		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST333				4					
					119811			4					
AN960JD6L *AN960JD6L* Washer		Purchased	No			110	Each	624.0000	 **	6 5519	-	12/11/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST337A				624					
					5519			624					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82597

82597

Parent Item: D412-761-043

D412-761-043

Parent Item Name: Modified Latch Mechanism, LH

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 3.00

Required Qty: 3.00

MS21042L06

Purchased

No

110

Each

218.0000

2

6

✓

MS21042L06

Nut

**

122441 JB

12/11/28

Shp 37

Location

Loc Qty

Loc Code

ST300

218

118354

2

119109

1

119758

1

120360

214

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-761 REV. D
INSTRUCTION FOR CONTINUED AIRWORTHINESS ICA-D412-761 REV. 1
AND INSTALLATION DRAWING D412-761-1 REV. D

REF. TCCA STC: SH09-4
REF EASA STC: 10028917

PURPOSE:

The purpose of this service instruction is to replace the MS16997-22 screw used in the latch assembly with MS16997-24 screw.

CHANGE:

5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD (IIN-D412-761)
52.10 PARTS LIST (ICA-D412-761)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH

IS:

	2				MS16997-24	SCREW
--	---	--	--	--	------------	-------

WAS:

	2				MS16997-22	SCREW
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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

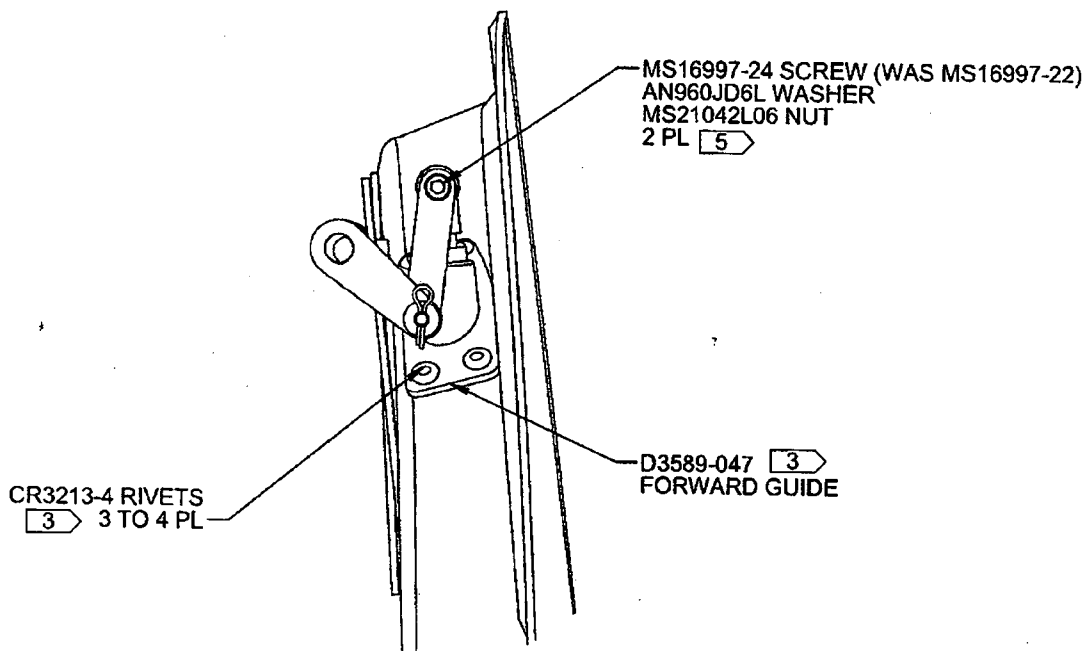
APPROVED

BY: [Signature]
D. SHEPHERD (DE #02)

DATE: 11-10-25
CERT. NO.: SH09-4
ISSUE NO.: 2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82593 M15
12/04/03

A	NEW ISSUE	XDF	11.10.25
REV.	DESCRIPTION	BY	DATE
DESIGN	XDF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9580	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SCREW REPLACEMENT	NTS
DATE	11.10.25	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



VIEW G
(FROM SHEET 7 OF INSTALLATION DRAWING D412-761-1)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.10.25
CERT. NO.: SH09-4
ISSUE NO.: 2

DESIGN	XDF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	XDF	
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9580 SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	SCREW REPLACEMENT NTS
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